

SLUT

Dart Aerospace Ltd.

Monday, 9/10/2007 1:19:09 PM  
Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 34478 **3**  
 Estimate Number : 12811  
 P.O. Number :  
 This Issue : 9/10/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1/1 Type : SMALL / MED FAB  
 Previous Run : 34260  
 Written By :  
 Checked & Approved By : **JA 07.09.10**  
 Comment : Est Rev. A New Issue 07-03.26 ec

Drawing Name : BRACKET  
 Part Number : D35921  
 Drawing Number : D3592 REV.B  
 Project Number : N/A  
 Drawing Revision : B  
 Material :  
 Due Date : 9/17/2007 Qty: **(5)** 48 Unit: Each

**POSITIVE RECALL**

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6S125

6061-T6 .125 Sheet



Comment: Qty.: 0.1460 sf(s)/Unit Total: 7.0056 sf(s)

6061-T6 .125 Sheet

Batch: **M104480****IB 07-09-11**

\*\*\*Grain must be Along 4.63\*\*\*

**GRAIN AT 45°, SEE DWG**

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3592

Dwg Rev: **B**Prog Rev: **B****IB 07-09-11****(5)**

2-Deburr if necessary

**/open hole to finished dim.****SAD 07/09/11 (5)**

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

**IB 07-09-11**

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

**En 07/09/12****(5) center**

5.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1

**\* Bend 3.5 only \***

Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Form as per Dwg D3592 using DT8949

**SAD 07/09/12****(5)**



Date: Monday, 9/10/2007 1:19:09 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 34478

Part Number: D35921

Job Number:



Seq. #:

Machine Or Operation:

Description:

60

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*E 07.10.01*

70

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *U*

*U 07.10.01*

80

QC21

FINAL INSPECTION/W/O RELEASE



*07.10.01*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07.10.01*

POSITIVE RECALL

EFFECTIVE *07.09.10* AUTH *U*

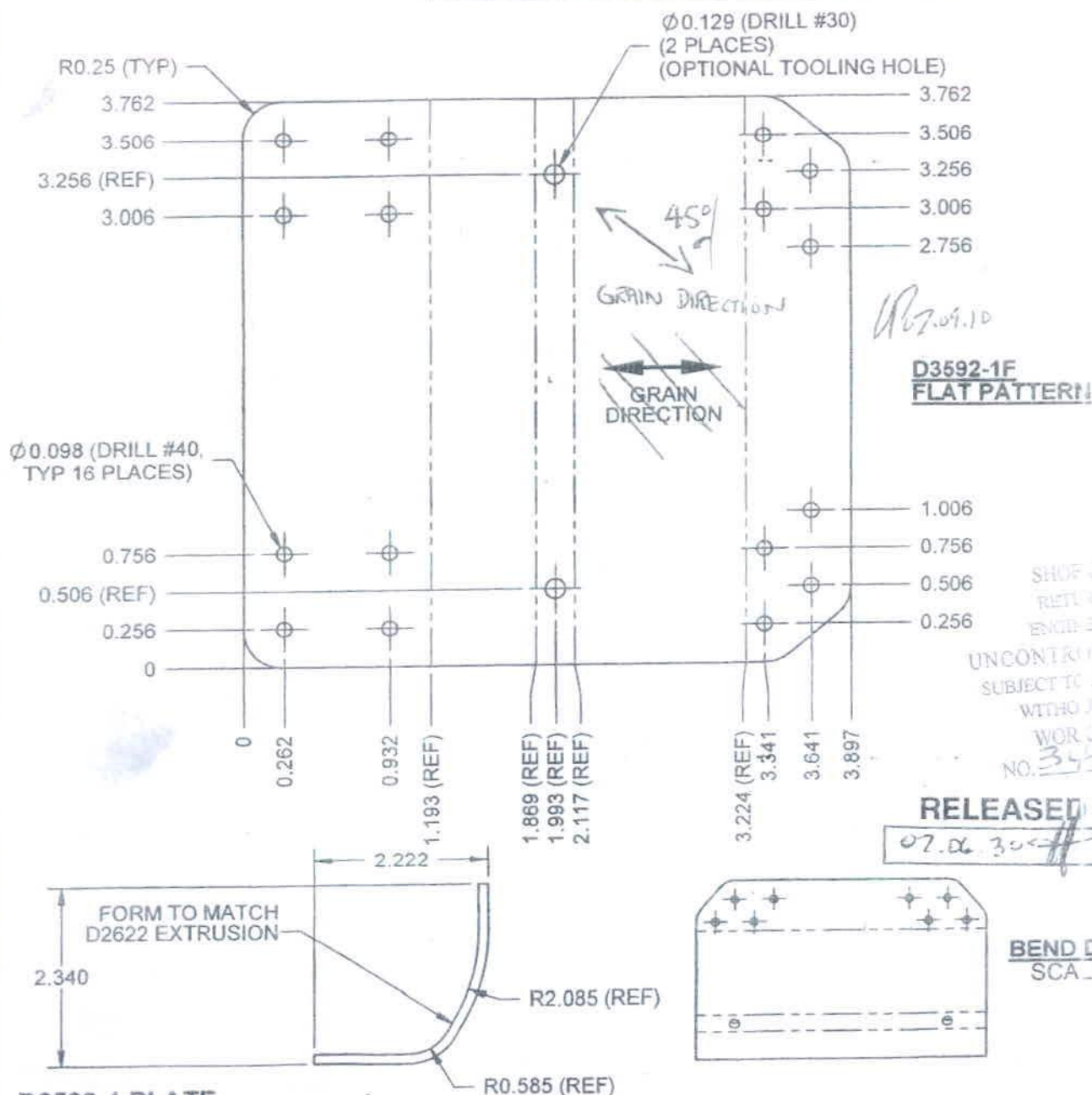
RELEASED *U* DATE *07.10.01*





**DART**

DESIGN <i>qp</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>qp</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3592</b>	REV B SHEET 1 OF 1
DATE <b>07.05.31</b>		TITLE <b>PLATE</b>	SCALE 1:1
A	07.01.15	NEW ISSUE	
B	07.05.31	TOOLING HOLES ADDED	

**D3592-1 PLATE****NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.125" THICK (QQ-A-250/11, REF DART SPEC. M6061T6S.125)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS 0.010 MAX

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AAR AEROSPACE LTD

Work Order: 34478

BRACKET

Part Number: D 3592-1

Dwg: D3592 Rev: B

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## FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☐

Prototype

		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø	.129	+ .005 - .001	.129				
Ø	.098	+ .004 - .001	.100				
	.256	+/- .010	.256				
	.756	+/- .010	.756				
	3.006	+/- .010	3.006				
	3.256	+/- .010	3.256				
	3.506	+/- .010	3.506				
	3.762	+/- .010	3.772				
	.262	+/- .010	.262				
	.932	+/- .010	.932				
	1.993	+/- .010	1.993				
	3.341	+/- .010	3.341				
	3.641	+/- .010	3.641				
	3.897	+/- .010	3.900				
	.256	+/- .010	.256				
	1.006	+/- .010	1.006				
	2.756	+/- .010	2.756				
	3.006	+/- .010	3.006				
	3.256	+/- .010	3.256				
	3.506	+/- .010	3.506				
	3.762	+/- .010	3.764				

IB

Audited by: *Sn*Prototype Approval: *n/a*

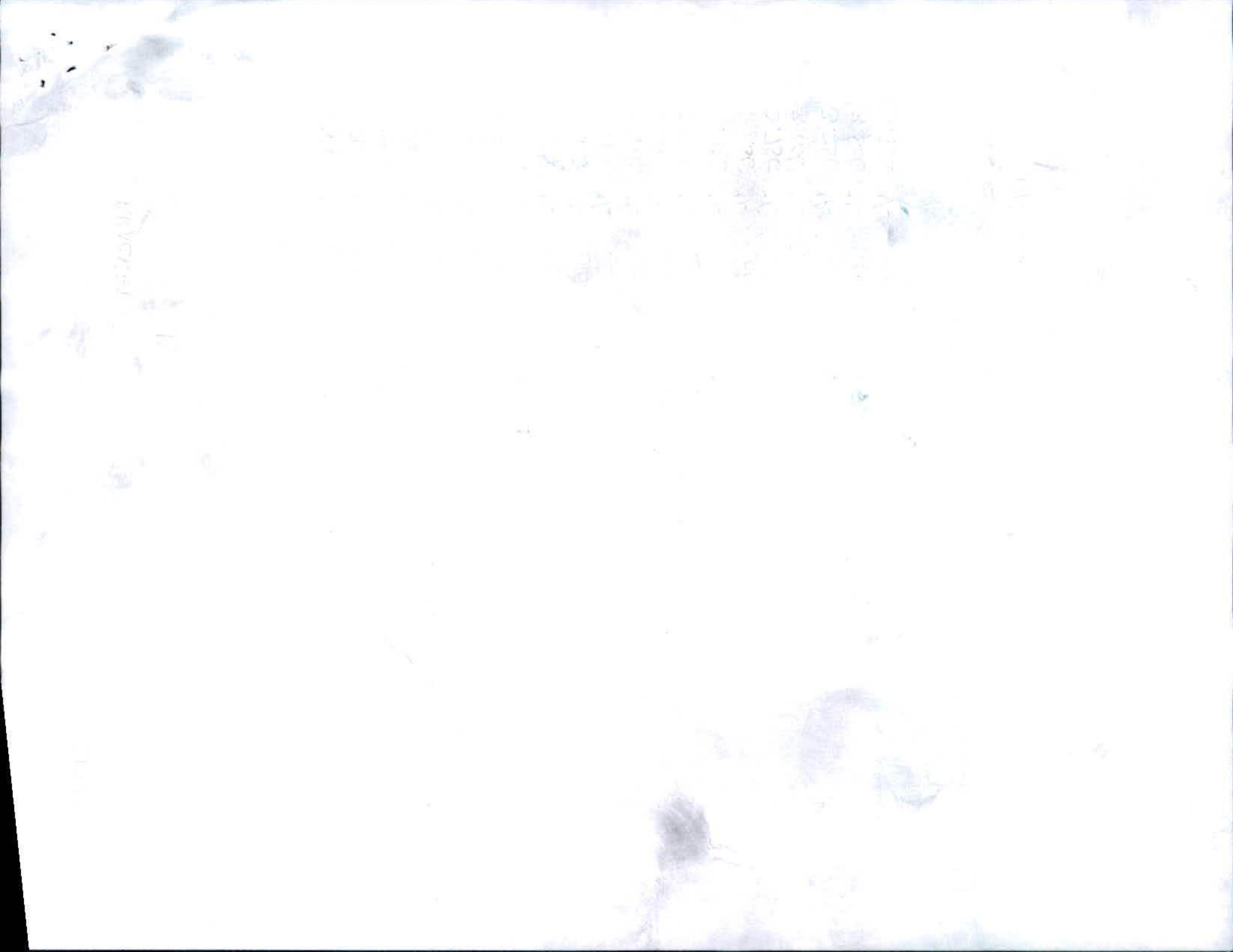
Date: 07-09-11

Date: 07/09/12

Date:

Change  
New IssueRevised by  
KJ/JLN

Approved





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3592-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>34478</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/01/12</u>	<u>5</u>	<u>1 piece was out of tolerance</u> <u>bad S/S</u>	<u>[Signature]</u> <u>ASIA/L</u>	<u>Scrap - destroy</u>	<u>S/S</u> <u>07/01/12</u>	<u>En</u> <u>07/01/12</u>	<u>[Signature]</u> <u>ASIA/L</u>	<u>En</u> <u>07/01/12</u>

NOTE: Date & initial all entries

